

Date: Friday, 19/06/2009 10:13:58 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GUSSET ASS'Y
Job Number :	48663		
Estimate Number :	13865		
P.O. Number :		Part Number :	D3929041
This Issue :	19/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3929 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	47958	Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	26/06/2009
Written By :			Qty: 6 Um: Each
Checked & Approved By :			
Comment :	Est Rev:A 09-04-20 new issue EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	M304S11GA	304/316 0.125 Sheet
	Comment: Qty.: 0.4725 sf(s)/Unit Total : 2.8350 sf(s) 304/316 .0125" Sheet Batch: <u>111018</u> <u>B 9-6-22</u> <u>SAD 09-06-19</u>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3929 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> <u>B 9-6-22</u> <u>7</u> 2-Deburr if necessary <u>B 9-6-22</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 9-6-22</u>	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK <u>S 02/06/22</u> <u>(X)</u>	
✓ 5.0	D39071	Bushing
	Comment: Qty.: 2.0000 Each(s)/Unit Total : <u>14</u> 42:0000 Each(s) Bushing Batch: <u>B48438</u> <u>SAD 09-06-22</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3907-1 as per dwg D3929

316L rod batch: H108160

PD 09.06.22 (7)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.06.22

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/22

(-041)

(+7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: Basket

PD 09.06.22 (7)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/25

Job Completion



mf
09-06-22

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8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

copy
of

D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED
5/24/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	09.04.03
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3929 TITLE GUSSET ASSEMBLY COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		
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DE APPR.				
DATE	09.04.03			

8 7 6 5 4 3 2 1

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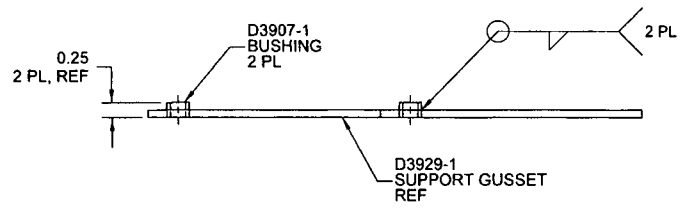
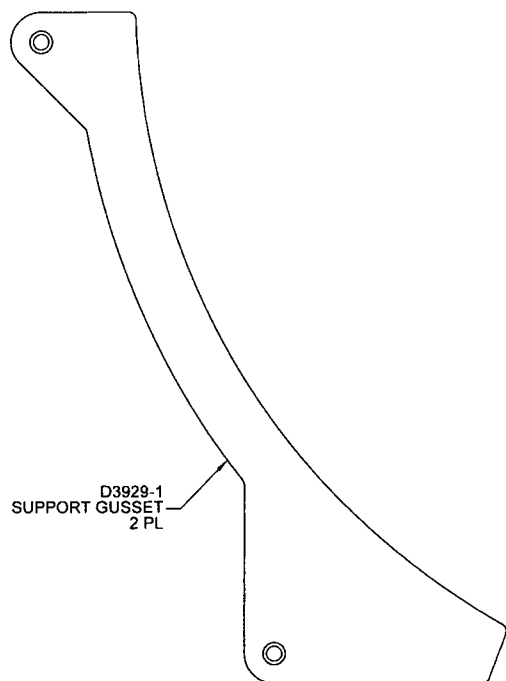
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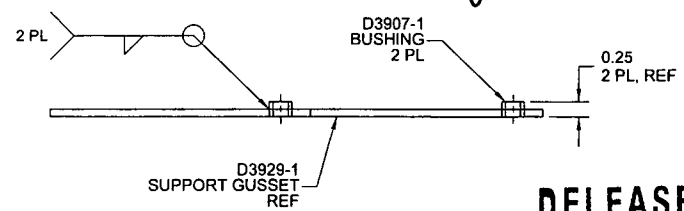
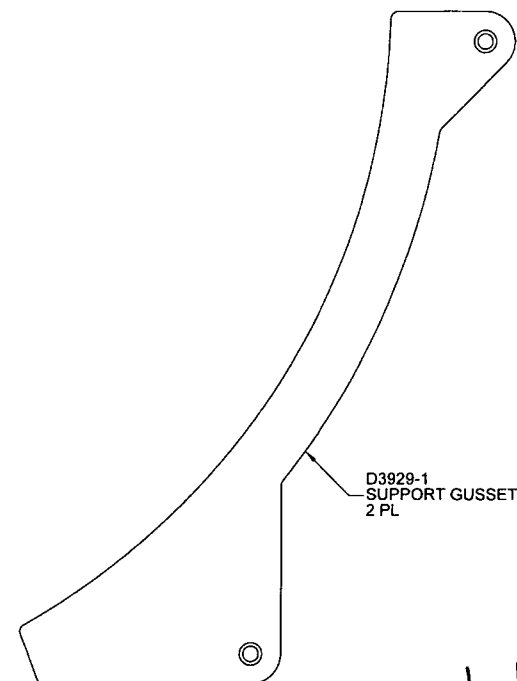
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A



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/2003

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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